

December-05-13 2:37:04 PM

Page 1

Stop *NR2*

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Page 2

Packaging

F. 4 14/01/09

8

0

CL 14/01/10 (8)

Page 13 of 8

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Page 3

Quality Control

05 14-01-31

DAS
32
9-89

17/01/31 (8)

MLJ 14-02-03

mf

14-1-31

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Picklist Print

December-05-13 2:37:08 PM

Page 1

Work Order ID: 109922

109922

Parent Item: D2224

D2224

Parent Item Name: Rappel Anchor Assembly

Start Date: 12/05/13

Required Date: 12/19/13

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:D02.04.23Add note for grain direction & inspect 8, 21NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T73B2.500X03.2 5		Purchased	No				f	1.4700		2			

M7075T73B2 500X03 25

**

DR/D.A.

7075-T73 Bar 2.50 x 3.25

14-01-07

Location	Loc Qty	Loc Code
MAT	1.47	
125584	1.47	
127864		

2 ft.

MAT'L NOT TAKEN
OUT OF STOCK.

DQA: _____ Date: _____



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DART AEROSPACE LTD		Work Order:	109922
Description: Rappel Anchor		Part Number:	D2224
Inspection Dwg: D2224 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.188	+/-0.010	.188	✓		DR 16	8" vern
0.050 x 45°	+/-0.010 x 0.5°	.050	✓		/	
0.250	+/-0.010	.247	✓		/	
R0.500	+/-0.010	.500	✓		RADIUS	Gauge.
3.000	+/-0.010	.3001	✓		DR 16	8" vern
Ø0.507	+0.008/-0.001	Ø .507	✓		PIN GAUGE.	
0.750	+/-0.010	.7485	✓		DR 16	8" vern
2.313	+/-0.010	2.312	✓			
1.687	+/-0.010	1.686	✓			
2.438	+/-0.010	2.439	✓			
1.125	+/-0.010	1.123	✓			
Ø0.313	+0.006/-0.001	.313	✓		PIN GAUGE.	

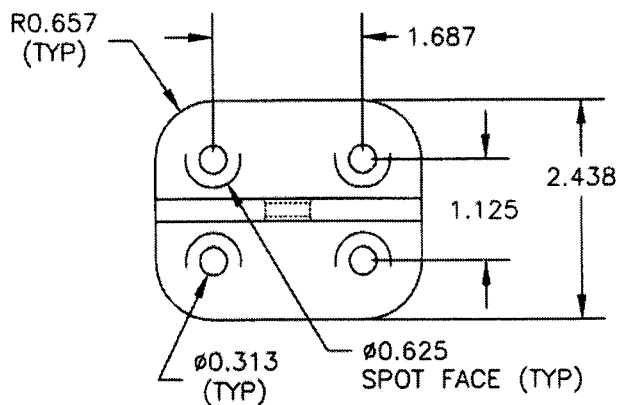
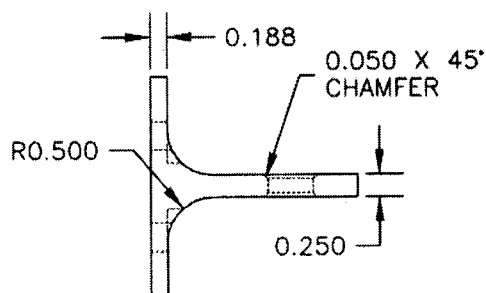
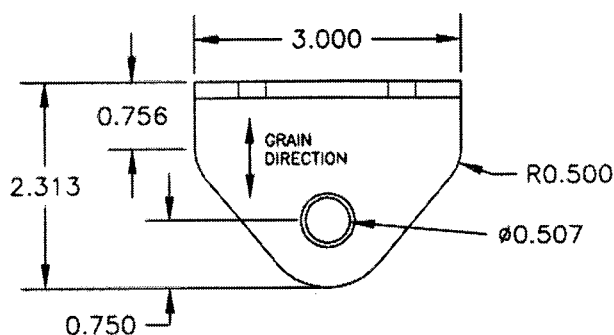
Measured by: DR/D.A.	Audited by: FK	Prototype Approval:	N/A
Date: 14-01-08	Date: 14/01/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.11	New Issue	KJ/DD	



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED RF	DRAWING NO. D2224	REV. E SHEET 1 OF 1
DATE 99.04.29	TITLE RAPPEL ANCHOR		SCALE 1:2
A	94.03.10	NEW ISSUE	
B	95.04.11	D2227 WAS D2216	
C	96.06.17	ADDED D2224-60	
D	97.04.25	CHANGE TO T-SHAPE	
E	99.04.29	REVISE MATERIAL SPECIFICATIONS	

RELEASED
99.09.11 KE



MATERIAL: 7075-T7351 (QQ-A-200/11) OR 7075-T651 (QQ-A-200/11)
FINISH : ANODIZE RED PER MIL-A-8625
BREAK ALL UNMARKED EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 62865

Date: 30-Jan-14

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To


DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description	Rev:	
1 lot	Part: ASST 8 PCS D2224 (2.00) RED ANODIZE MIL-A-8625 TYPE II CLASS 2 20 PCS 646.3110 (10.65) 9 PCS 646.3210 (14.35) 12 PCS 646.3310 (18.10) 12 PCS 646.9712 (14.50) 10 PCS 647.0310 (11.10) 10 PCS 647.9314 (11.05) 3 PCS 647.9316 (10.00) 15 PCS 647.9610 (16.05) 20 PCS 647.9612 (16.05) 12 PCS 649.5312 (10.15) HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N PRICE IS PER PIECE Job: 20140079	Line:	
Certificate of Conformance			
A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.			
ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY			
DATE: 30/1/14			
CERTIFIED SIGNATURE: 			
RECEIVER SIGNATURE: _____			



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO22580**

Purchase Order Date 1/10/2014

PO Print Date 1/30/2014

Page Number 2 of 7

Order From :

VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-446-4544

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

3	109974	D1038-58B RAIL	1/24/2014 Yes 1/24/2014	60.00	\$2.25	\$135.00
FINISH: BLACK ANODIZE PER MIL-A-8625F TYPE I OR IB/II/III CLASS 2						
						Line Total: \$135.00
4	109921	D2056 BELL CRANK ASSEMBLY	1/24/2014 Yes 1/24/2014	20.00	\$1.25	\$25.00
FINISH: BLACK ANODIZE PER MIL-A-8625F TYPE I OR IB/II/III CLASS 2						
						Line Total: \$25.00
5	109922	D2224 RAPPEL ANCHOR ASSEMBLY	1/24/2014 Yes 1/31/2014	8.00	\$2.00	\$16.00
FINISH: RED ANODIZE PER MIL-A-8625F TYPE I OR IB/II/III CLASS 2						
						Line Total: \$16.00

Note:

1/30/2014

